

Del 1"

Work Order ID 85659

June-13-12 12:57:31 PM

ASAP

85659

Page 1

Item ID: D4008-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Washer

Start Date: 13/06/2012 Start Qty: 30.00 *30*

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 30.00 *30*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12/06/13 Tooling:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4008	C
-------	---

100

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER DWG AND FOLIO FA909

DWG REV: C

FOLIO REV: AA

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12/06/14

30 0

SL 12/06/14

30 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85659

85659

Page 2

June-13-12 12:57:31 PM

Item ID: D4008-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Washer

Stop ***NS2***

Start Date: 13/06/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

120

OK 12/06/12

QC

Memo

0.00

Quality Control

30 0

130

Identify as per dwg & Stock Location: *083*

0.00

130

Packaging

Memo

0.00

Packaging

12/6/18 (30)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/18

MF 12-06-18

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-13-12 12:57:36 PM

Page 1

Work Order ID: 85659

85659

Parent Item: D4008-7

D4008-7

Parent Item Name: Washer

Start Date: 13/06/2012

Required Date: 20/06/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 10-02-02 JLM VERIFIED BY:EC IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07
AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	24.0332	0.028	0.884211			
MDFI RINR1 000										**	713	<i>12/06/12</i>	
Delrin Round Bar 1"													

Location

Loc Qty

Loc Code

MAT055

24.0332

117985

0.407

118392

6.2762

119306

17.35

713

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue	KJ	
B	12.03.08	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

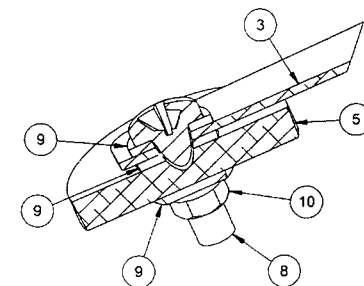
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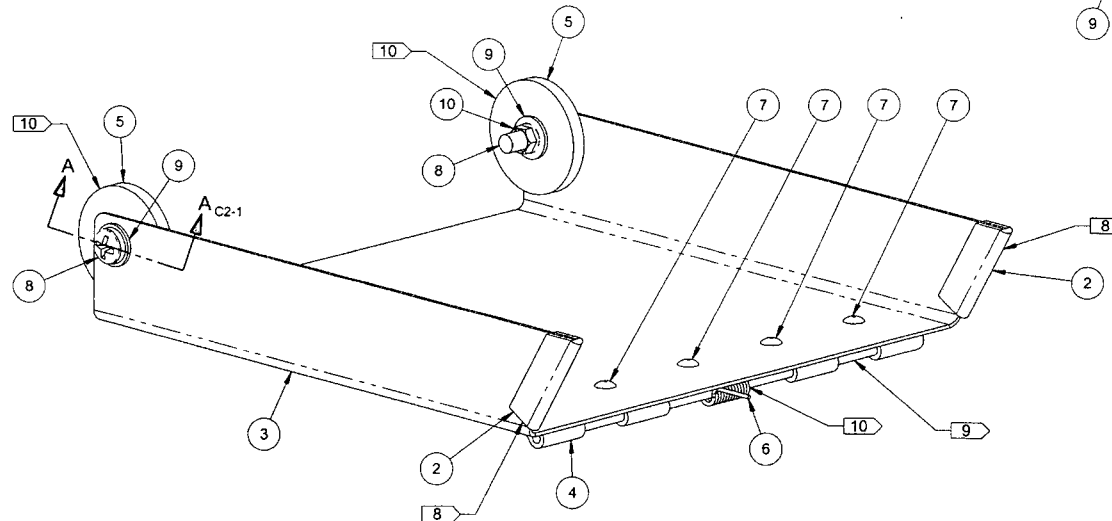
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



SECTION A-A
SCALE: 2X B6-1
TYP



RETURN
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
85659 MLJ
12/06/13

D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

RELEASED
2012-03-02
JWP

REV.	DESCRIPTION	BY	DATE
C	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY". CORRECT MATERIAL ERROR, ZN A7-6. ADD D4597-1 TO D4008-043, ZN C4-2.	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
DESIGN	DRAWN	CHECKED	MFG. APPR.
APPROVED	DE APPR.	DATE	12.01.17
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W/O:		WORK ORDER CHANGES					
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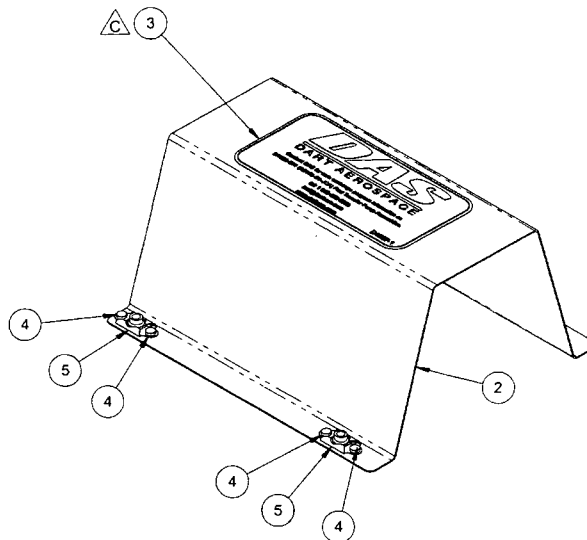
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	1	D4597-1	PLACARD	
4	8	MS20472M3-3	RIVET	
5	4	MS21060L3	ANCHOR NUT	



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL:
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.46 lbs

DESIGN	<i>JE</i>	DART AEROSPACE LTD	
DRAWN	<i>JC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JE</i>	DRAWING NO. D4008	REV. C
MFG. APPR.	<i>JE</i>		SHEET 2 OF 10
APPROVED	<i>JE</i>	TITLE SPLASH GUARD	SCALE NTS
DE APPR.	<i>JE</i>		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

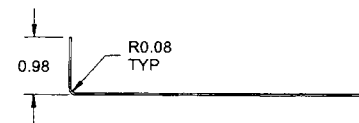
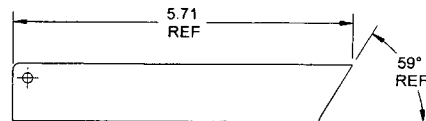
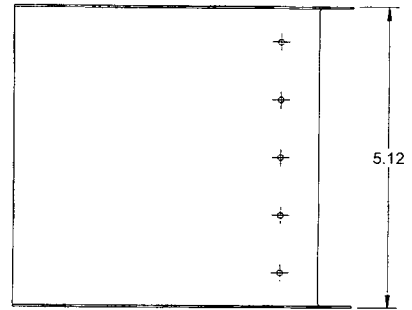
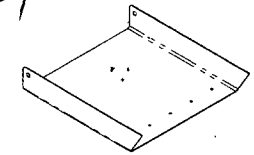
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-1	REF JCA-M47-2-26

25659



D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

RELEASED
2012-03-02
JMP

NOTES:

- 1) MATERIAL: MADE FROM D4008-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD
DRAWN	<i>DL</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>DL</i>	DRAWING NO. D4008 REV. C
MFG. APPR.	<i>DL</i>	SHEET 3 OF 10
APPROVED	<i>DL</i>	TITLE SPLASH GUARD SCALE NTS
DE APPR.	<i>DL</i>	
DATE	12.01.17	

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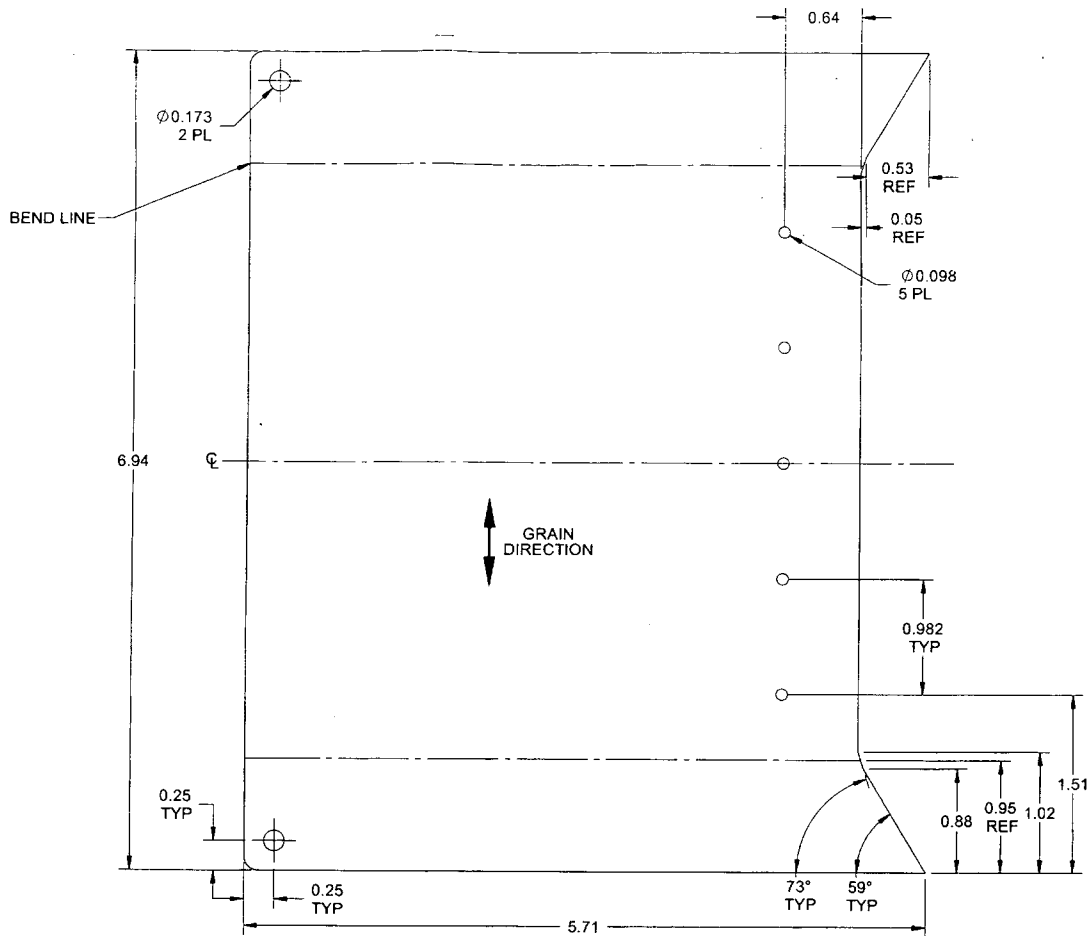
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4008-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4008	REV. C
MFG. APPR.			SHEET 4 OF 10
APPROVED		TITLE SPLASH GUARD	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

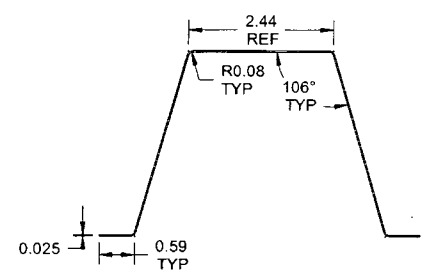
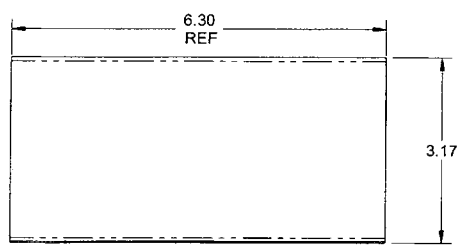
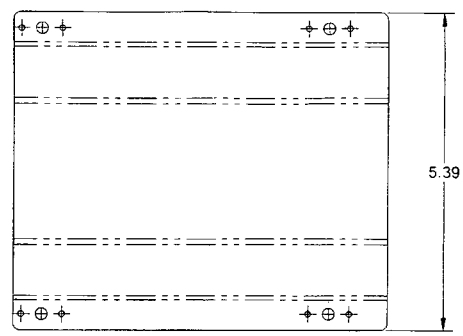
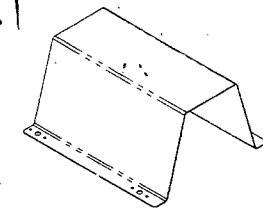
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-3	REF JCA-M47-2-29

85659



D4008-3 FUEL PUMP SPLASH GUARD COVER

2012-03-02
wD

- NOTES:
- 1) MATERIAL: MADE FROM D4008-3F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.45 lbs

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4008	SHEET 5 OF 10
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	SPLASH GUARD	NTS
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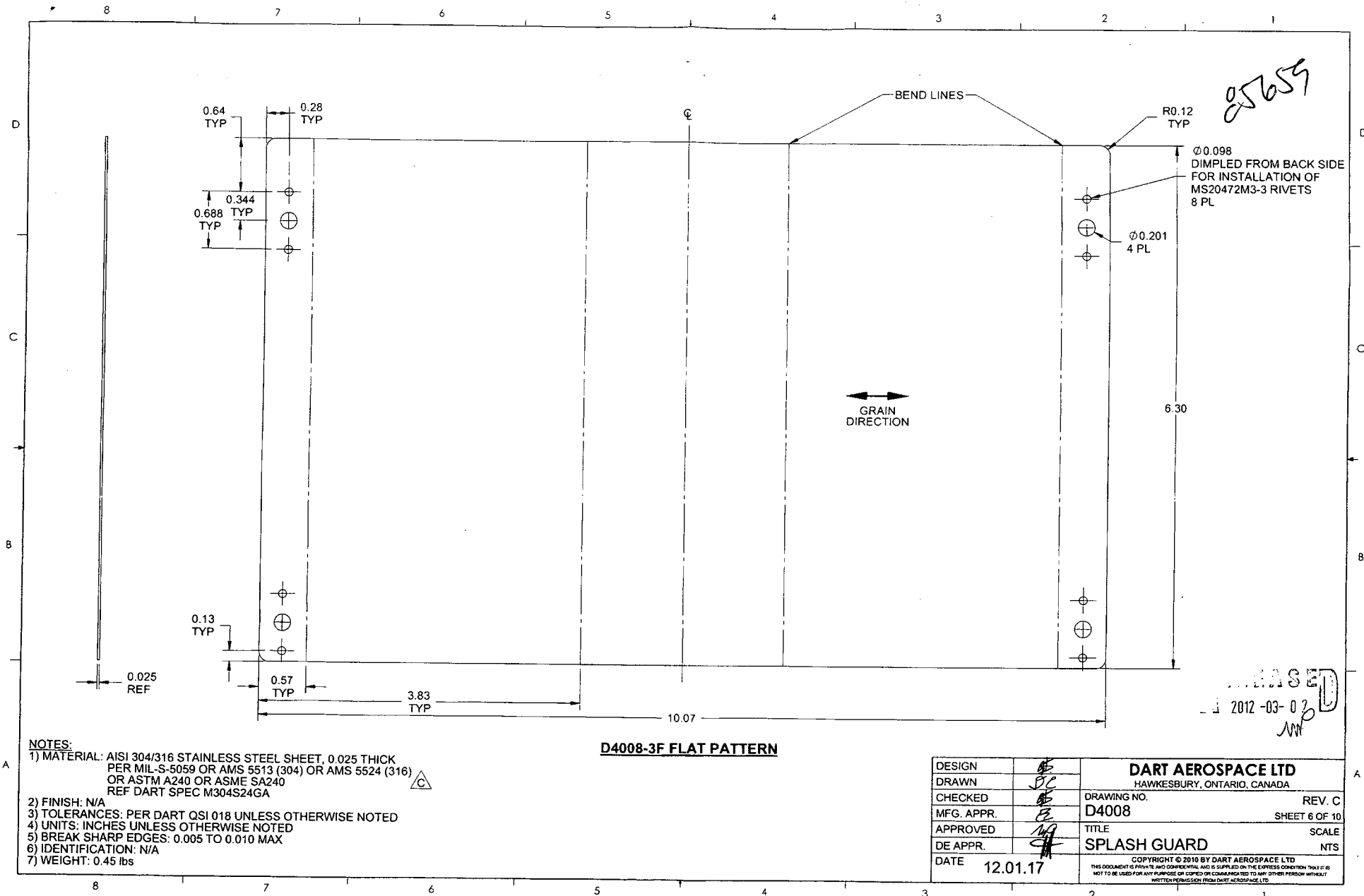
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.025 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S24GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.45 lbs

D4008-3F FLAT PATTERN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4008	SHEET 6 OF 10
APPROVED		TITLE	SCALE
DE APPR.		SPLASH GUARD	NTS
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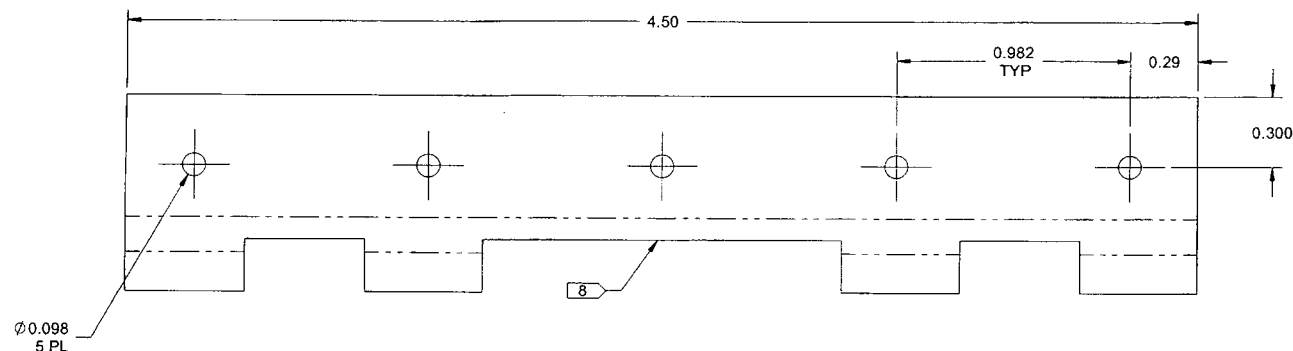
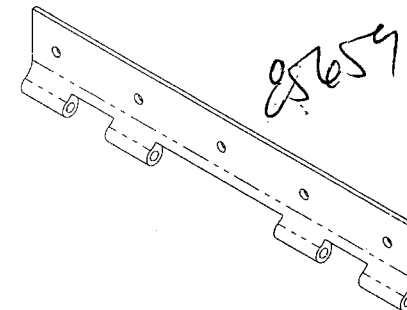
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NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-5	REF JCA-M47-2-26



D4008-5 HINGE HALF

RELEASED
2012-03-02

- NOTES:
- 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs
 - 8) REMOVE CENTER LUG FROM THIS AREA, FLUSH WITH THIS EDGE

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4008	SHEET 7 OF 10
APPROVED	MD	TITLE	SCALE
DE APPR.	JS	SPLASH GUARD	NTS
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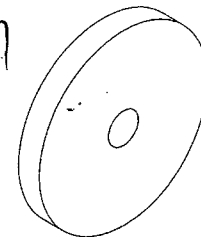
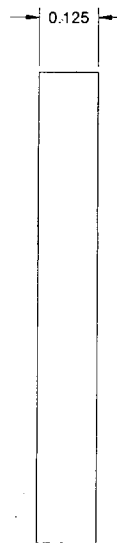
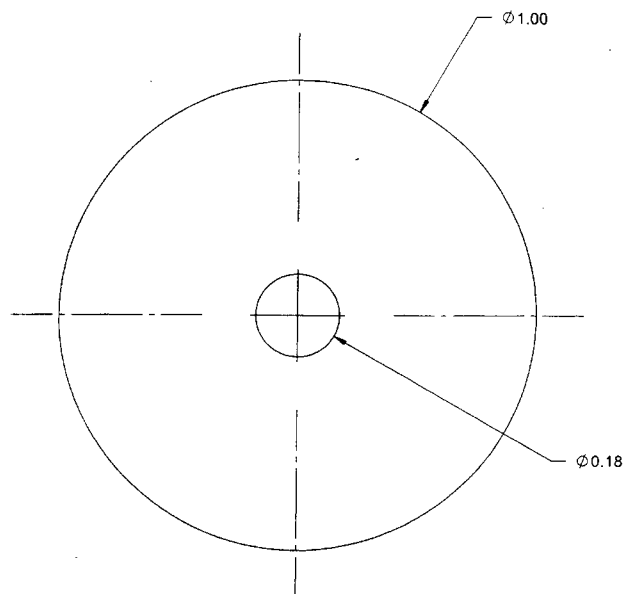
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-7	REF JCA-M47-2-26



D4008-7 WASHER

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø1.00 ROUND BAR, BLACK
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO. D4008	REV. C
MFG. APPR.	<i>JS</i>		SHEET 8 OF 10
APPROVED	<i>JS</i>	TITLE SPLASH GUARD	SCALE
DE APPR.	<i>JS</i>		NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

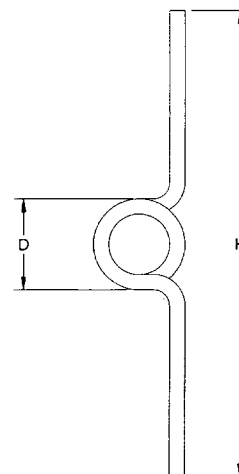
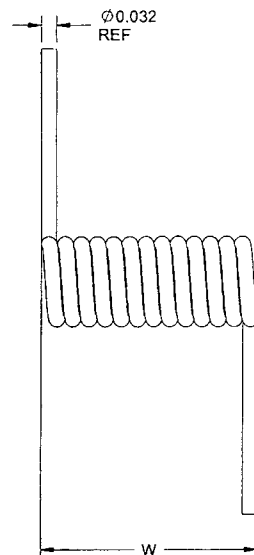
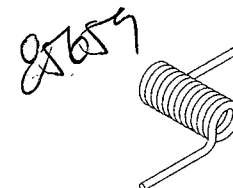
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER
D4008-9

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-2-26

SPECIFICATION CONTROL DRAWING



DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

D4008-X SPRING

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: T301 OR 304 STAINLESS STEEL SPRING WIRE $\phi 0.032$ PER ASTM A313
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	JS	DRAWING NO. D4008	REV. C
MFG. APPR.	JS	SHEET 9 OF 10	
APPROVED	JS	TITLE SPLASH GUARD	SCALE NTS
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DATE	12.01.17		

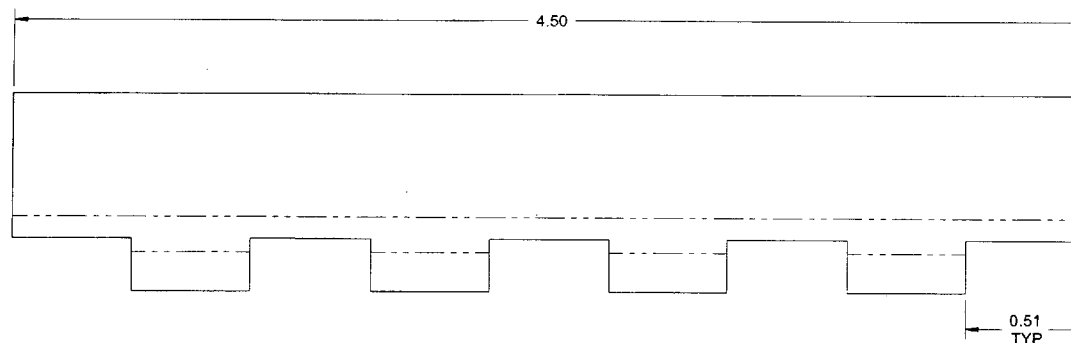
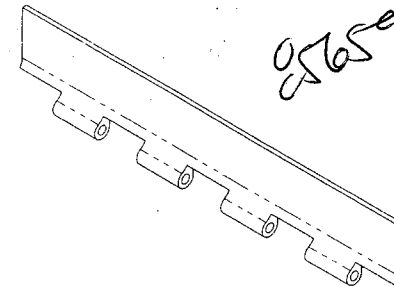
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4008-11 TANK HINGE HALF

RELEASED
11 2012-03-02
WAP

- NOTES:
- 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: STOCK AS D4008-11
 - 7) WEIGHT: 0.02 lbs

DESIGN	JS	DART AEROSPACE LTD	
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CHECKED	JS	DRAWING NO. D4008	REV. C
MFG. APPR.	E	SHEET 10 OF 10	
APPROVED	WAP	TITLE	SCALE
DE APPR.	WAP	SPLASH GUARD	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries